

Work Order ID 66558

Tuesday, February 22, 2011 9:51:21 AM

Page 1

Item ID: D3535-15

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 2/23/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: CMF Date: 11-02-2011 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-

Deburr if necessary

B11-2-23

(13)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

Quality Control

0.00

B11-2-23

120

0.00



QC

QC8- Inspect parts - second check

Memo

Quality Control

0.00

Sulu2/23

(+13)

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

0.00

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 13-Identify as D3535-15

SD 11/02/08
8/31/02/08

13

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

8 11/02/08

13

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

START TIME: 320^{OF} COVEN TEMPERATURE:

9:20 FINISH TIME: 9:30

M 115128

13x m-1 11/03/01

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Picklist Print

Tuesday, February 22, 2011 9:51:18 AM

Page 1

Work Order ID: 66558



Parent Item: D3535-15



Parent Item Name: Wearshoe


Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	111.0938	1.0205	12.89053	13.5	1811-2-23	

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT

111.0938

115953

21.6

116437

52.2538

116623

37.24

116437

13

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DART AEROSPACE LTD		Work Order:	06558
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	X		V HB02	
2.000	+/-0.010	2.000	X		V	
5.650	+/-0.010	5.650	X		T HB01	
9.150	+/-0.010	9.150	X		T	
14.400	+/-0.010	14.400	X		T	
19.650	+/-0.010	19.650	X		T	
24.900	+/-0.010	24.900	X		T	
30.150	+/-0.010	30.150	X		T	
33.650	+/-0.010	33.650	X		T	
35.650	+/-0.010	35.650	X		T	
39.150	+/-0.010	39.150	X		T	
Ø0.188	+0.005/-0.001	.194	X		V	
24.00	+/-0.030	24.00	X		T	
16.00	+/-0.030	16.00	X		T	
8.00	+/-0.030	8.00	X		T	
5.00	+/-0.030	5.00	X		T	
0.300	+/-0.010	.305	X		V	
0.300	+/-0.010	.306	X		V	
0.038	+/-0.010	.035	X		V	

Measured by:	IB
Date:	4-2-23

Audited by:	S
Date:	11/02/23

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

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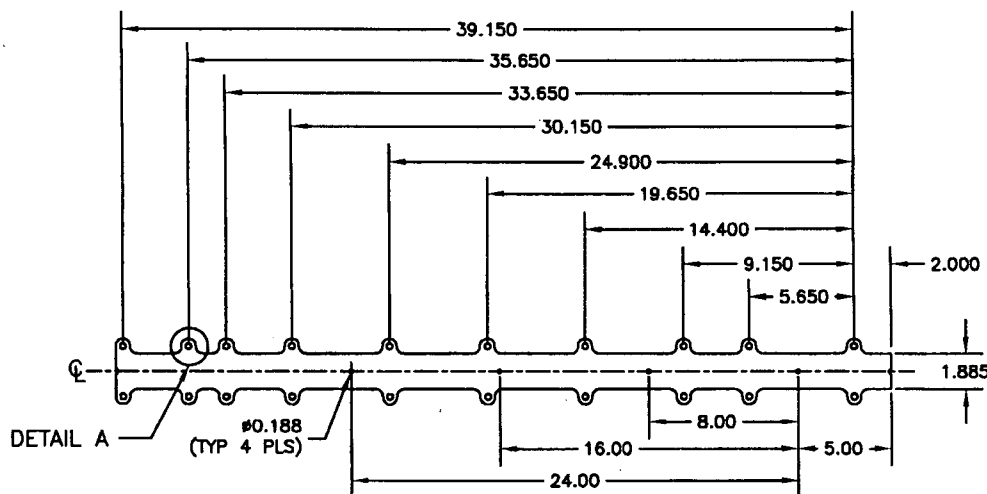
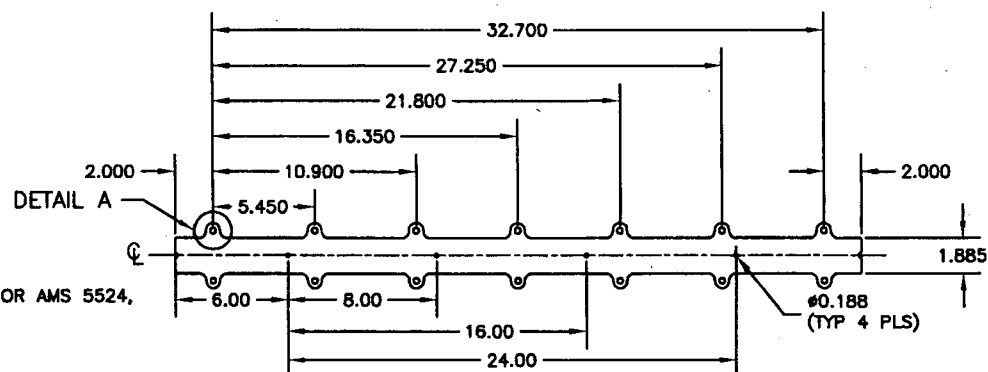
NOTE: Date & initial all entries

DART

RELEASED

07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 2 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

**D3535-15F FLAT PATTERN**4.50 TO BEND
LINE (ON FLAT
PATTERN)0.32
(REF)**D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN**

DETAIL B

D3535-21 BEND DETAIL**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

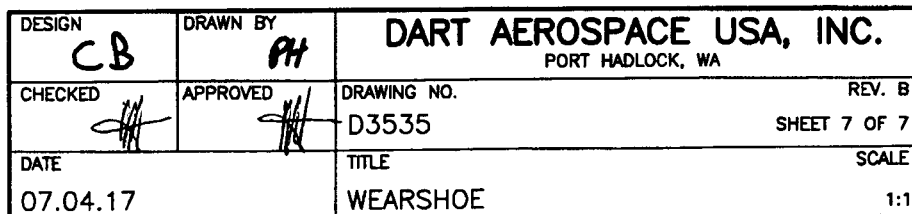
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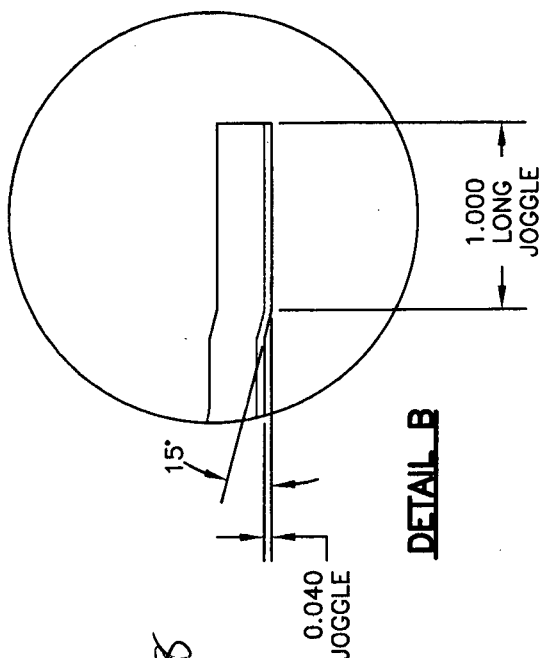
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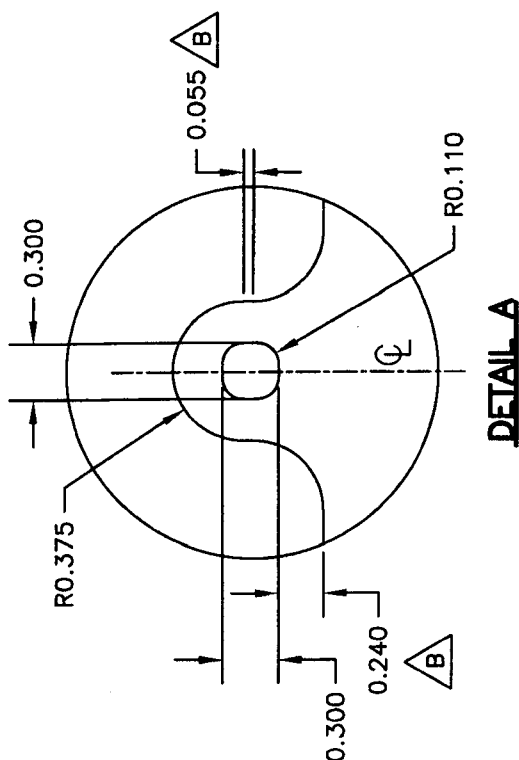


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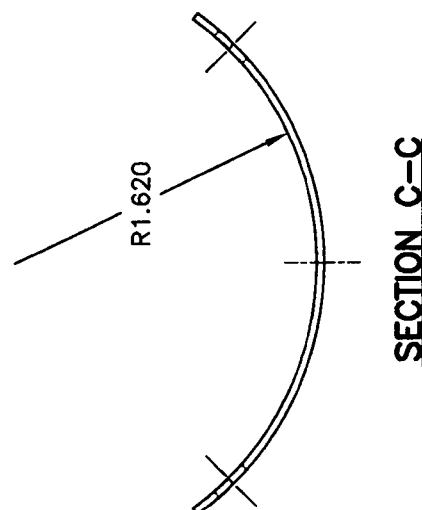
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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